

Oversized Rear Case Bushing

Part No.
36008C



NOTE: Fits '95-later units only; 3 grooves to front and 1 to back. Must be installed with Sonnax bushing installation tool listed below.

Bushing Installation Tool

Part No.
T36008A

Reamer

Part No.
T36605-03

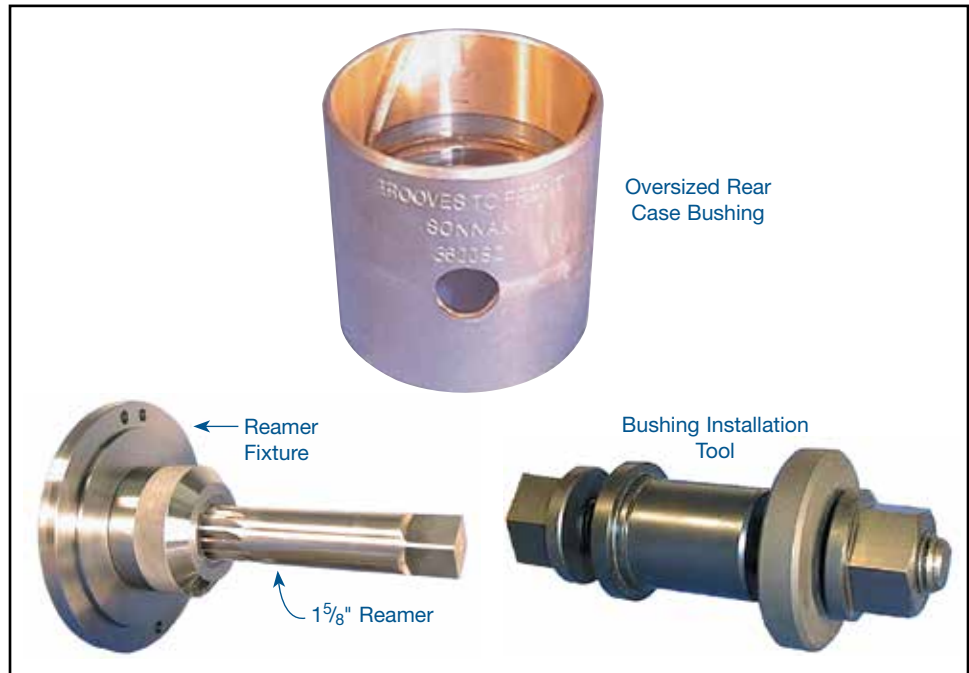
NOTE: Required tool T36605-03 is no longer in production. Check with your distributor for availability.

Reamer Fixture

Part No.
T36605-04

NOTE: Required tool T36605-04 is no longer in production. Check with your distributor for availability.

Ford 4R100, E40D



1. Disassembly

Remove spun-out OE bushings from transmission case.

2. Reaming

- a. Ensure proper side of Sonnax reamer fixture T36605-04 is facing case and bolt fixture to rear of case. Sonnax reaming fixture should mount flush to the transmission case (**Figure 1**).



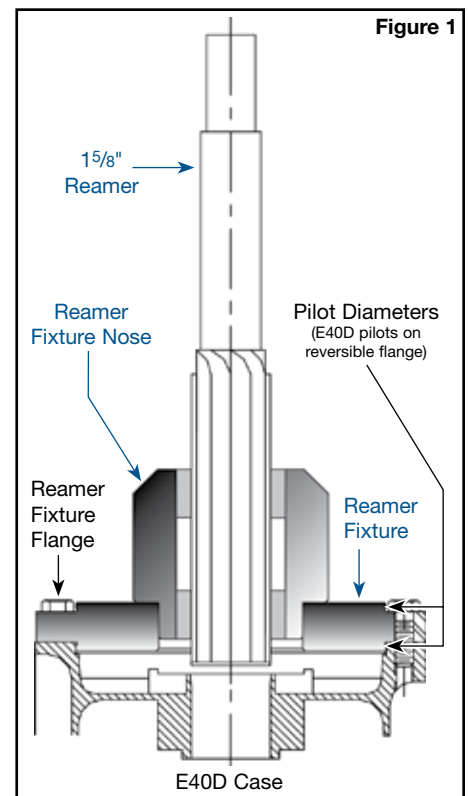
NOTE: If Sonnax reaming fixture T36605-04 is not available, the case bore can be machined to a housing diameter between 1.6245–1.6255". This will result in a press fit of .0010–.0030".

- b. Coat reamer and case bore with cutting fluid.
- c. Using light pressure, ream the case bore with T-handle and socket.



NOTE: Place a board or layer of cardboard on the floor to prevent damaging the reamer if it is dropped.

- d. Remove reamer fixture from the transmission case and clean any chips from the bore.



3. Installation & Assembly

- a. Using a high-speed cutting wheel, cut a notch into case as shown (Figure 2).
- b. Mark the case where lube hole is bored to assist with proper bushing alignment (Figure 3).
- c. Mark the Sonnax bushing for proper alignment with lube hole (Figure 4).
- d. Apply bearing sealer such as Loctite® 609 or equivalent to case bore (Figure 5).
- e. Align lubrication hole on Sonnax bushing with lube hole in case (Figure 5).
- f. It is important to use Sonnax installation tool **T36008A** to prevent deformation of the long, thin-walled bushing. In addition, the tool shoulder is designed to seat the bushing at proper depth. Install Sonnax bushing with grooves toward front of case.
- g. Stake bushing in place at notch (Figure 6).
- h. Confirm lubrication holes are properly lined up and that acceptable clearance has been maintained between bushing and output shaft.

